

Work Order ID 56451

February 24, 2010 8:07:48 AM



Page 1

Item ID: D4050-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Strut

Start Date: 2/24/10 Start Qty: 3.00



Cust Item ID:

Required Date: 2/25/10 Req'd Qty: 3.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4050

B

100

0.00



Brake NC

NC BRAKE

Memo

0.00

Brake NC

Punch per Dwg. D4050 and Spec Control Dwg D2638

SB 10/02/24

8

110

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

Deburr

SB 10/02/24 3

120

0.00



QC

QC5- Inspect part completeness to step on W/O

Memo

0.00

Quality Control

SB 10/02/25

X3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Date:

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Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130



Powdercoat

Powder Coating

White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel

M113170

0.00

0.00

10/02/25

X3

Ø

Memo

START TIME: 11:15AM
OVEN TEMPERATURE: 400°F
FINISH TIME: 11:45AM

140



QC

Quality Control

QC3- Inspect Part Finish

0.00

0.00

Memo

3

1002-25

150



Packaging

Packaging

Identify as per dwg & Stock Location:

254

0.00

0.00

Memo

R14/3/01 (3)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Customer:

Reference:

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Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/03/03

CL 03/01/10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 56451

Parent Item: D4050-3

Parent Item Name: Strut

Comments: IPP Rev/A: new issue DD 10/01/05 verified by:EC IPP Rev:B as per dwg
revB DD 10.02.18 verified by:EC

Start Date: 2/24/10

Required Date: 2/25/10

Start Qty: 3.00

Required Qty: 3.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M304TR0.750W.065		Purchased	No			110	f	206.8773	3.9183			



304 RD Tube .750 x .065W

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
------------------	----------------	-----------------

Main Warehouse

MAT

206.8773

110113

106.8773

114002

100

4.2 85 10/02/24 ③

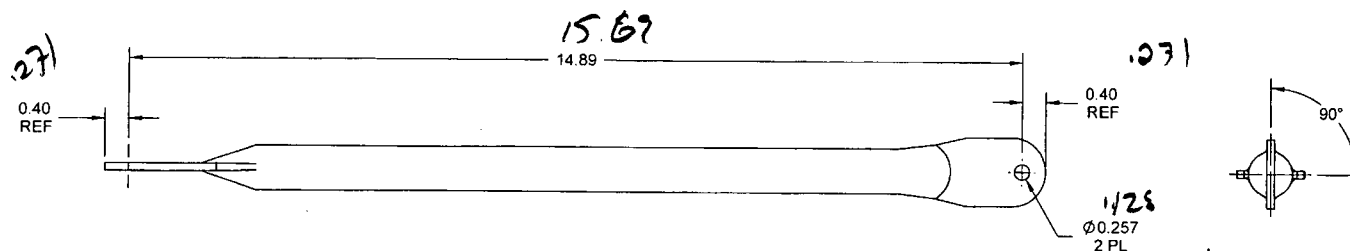
W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries







8 D4050-3 STRUT

W056451

RELEASED
2010-02-16

- NOTES:**
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SEAMLESS TUBE $\phi 0.750 \times 0.065$ WALL
REF DART SPEC M304TR0.750W.065
 - 2) FINISH: POWDER COAT "WHITE" (4.3.5.2) PER DART QSI 005 4.3
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER
 - 7) WEIGHT: 0.58 lbs
 - 8) PUNCH BOTH END PER SPEC CONTROL DRAWING D2638

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D4050	SHEET 2 OF 4
APPROVED		TITLE	SCALE
DE APPR.		STRUT	NTS
DATE	10.02.02	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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